

5259260



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5785-1

Job Sheet 207417

NO 20.02.28



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Part No: D5785-1

Job Qty: 20 pcs

Part Name: Lid Bracket



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Placed by _____ Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG 5785 REV.A IPP REV:A NEW ISSUE 20.14.01 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	3/6/20	3/6/20	0.17	1.26	Waterjet - Flow		20/02/28
110	QC 2	20 pcs	3/6/20	3/6/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/02/28
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

PRIORITY

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	QC 8	20 pcs	3/6/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Packaging 3-1 - Stock - B4B	20 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B

FFB 2 8 2020

Dns
40
8-89

MB92

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	20 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	21 FEB 28 2020
				QC 21 - SA - 70	70
				QC 21 - SA - 53	

Part Op 100 - Cut D5785-1 as per dwg Prog Rev: A Dwg Rev: A Deburr as required

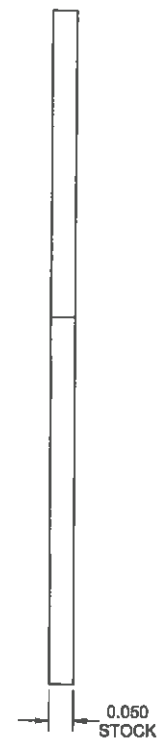
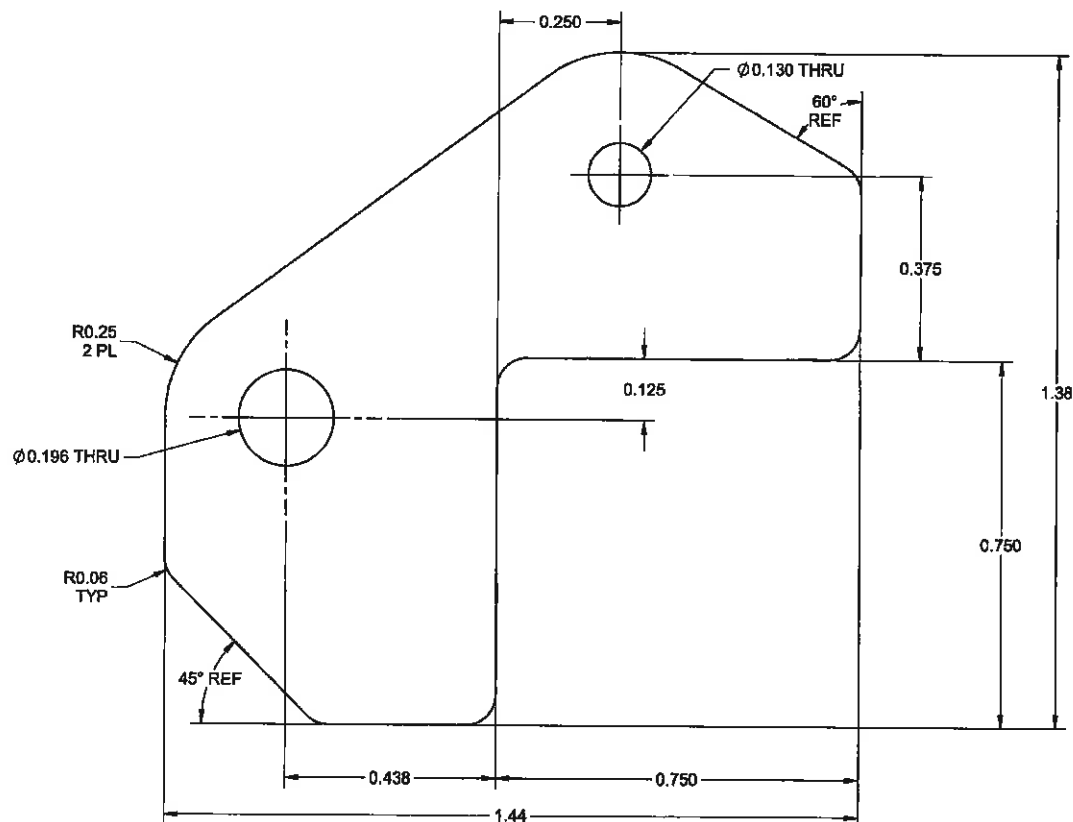
Descriptions: 110 - QC2- inspect parts off machine FAI/FAIB
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.2880 sf (.0144 ea)	100-Waterjet - Flow - 4	3243764 3243764

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 4	M304S18GA	0	585	0

Part Specifications	
Specifications could not be found.	

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207417

MW
200226

D5785-1 BRACKET
(DERIVED FROM AERO DESIGN P/N 36273-01)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

- NOTES:**
- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED, #18 GA (0.050 THICK)
PER MIL-S-6059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.01 lbs
 - 8) ALL NON-DIMENSIONED FEATURES WITHIN 0.030 OF "D5785-1-REVA.DXF"

RELEASED
2020 FEB 18 *NO*

APPROVED

DESIGN ZF
DRAWN ZF
CHECKED KPT
MFG. APPR. DD
APPROVED NO
DE APPR. CP
DATE 20.01.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5785**
TITLE **HANDLE BRACKET**

REV. A
SHEET 2 OF 3
SCALE
NTS

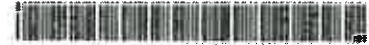
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045418**



Supplier: ACI301-VC
Adler Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5896

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045418

PO Date: 12/17/19

Due Date: 12/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: QUOTE NO. SOU0230838

DEC 17 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M5083T5C.75X.75W.125			6083-T5 Channel 0.750" x 0.750" x 0.125" wall receive ft	Firmed -		12/20/19	21 ft	214	0 ft	\$1.008/ft	\$21.13
2		M5083T5A0.750W.093			6083-T5 Angle .750 X.750 X.093 WALL receive ft	Firmed -		12/20/19	21 ft	341	0 ft	\$0.3757142/ft	\$7.89
3		M304S18GA			304/316 050 Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5359 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		12/20/19	320 of	0 of	320 of	\$5.6679375/ft	\$1,813.74

DEC 23 2019

DEC 23 2019

DEC 23 2019

OAS
82
6-89

**ACIER OUELLETTE INC.**

931, Boul. du Havre
Sasaberry de Valleyfield (Quebec) J6S 5L1
Tel: 450-377-4248 MH: 514-336-4248 Ext.: 800 667-4248
Fax: 450-377-5696 MH: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT*CR 80*

C000184919

Billed to DART AEROSPACE LTD 1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7	Shipped to 1270, ABERDEEN ST. HAWKESBURY, Ontario, K6A 1K7 Att : CHANTAL Delivery Route 5 + Palets 4'x8'	Customer N° Date Delivery date Your order N° Processed by Salesman Carrier Credit Terme	CLIC001056 2019/12/17 2019/12/19 POHB045418 Josianne Bourdon JOSIANNE BOURDON OUELLETTE VALLEYFIELD Net 30 Days
Instruction F M			

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CHANNEL ALU 3/4 X 3/4 X 1/8 6063-T5 * CHAL-343418 1981 1 X 21' POHB045418 LINE 1 CAST; 19193172	6.17	21.00	PI SCLB		21'						
2 ANGLE ALU 3/4 X 3/4 X 1/16 C 6063-T5 * AAL-3434116 1361 1 X 21' POHB045418 LINE 2 CAST-411324	2.25	21.00	PI SCLB		21'						
3 SHEET SS 18G SS304-2B DART FESSD-18G3042B-V 12468 10 X 4' X 8' POHB045418 LINE 3 HEAT YU187124 PACKAGING	672.00	370.00	PI2 SCLB		10X						
4 SHEET SS 11G SS304-2B (4 X 8) FESS-11G483042B 3402 2 X 4' X 8' POHB045418 LINE 1 HEAT D73E	336.00	64.00	PI2 SCLB		2X						
5 SHEET SS 14G SS304-2B (4 X 8) FESS-14G483042B 3412 2 X 4' X 8' POHB045418 LINE 3 HEAT L25HC10	209.98	64.00	PI2 SCLB		2X						

LIVE?

MATERIAL RECEIPT INSPECTION FORM

POMBOYS 113

MATERIAL: M304S/SEA

PO / BATCH NO.: POMBOYS 113

DATE: DEC 24 2019

5243464

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 32058
 QUANTITY INSPECTED: 32058
 QUANTITY REJECTED: 458

THICKNESS ORDERED: .050
 THICKNESS RECEIVED: .050
 SHEET SIZE ORDERED: 4' x 8'
 SHEET SIZE RECEIVED: 4' x 8'

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	CIRCLED SPOTS ON SHEET (1)
CORRECT FINISH	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORROSION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT MATERIAL PER M.DRAWING	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	ASIM A240
CORRECT THICKNESS	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
PHOTO REQUIRED	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT REF # TO LINK CERT	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	HTC 70187124
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
CORRECT M# ON THE MATERIAL	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	<input checked="" type="checkbox"/> Y	<input type="checkbox"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>82</u>	SIGNED OFF BY: _____
DATE: <u>DEC 24 2019</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LINE 3

KIT YU187024

M304S186A

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET (ANNEAL ED)

DAS
82
9-88

DEC 2 6 2019

SPECIFICATION

ML-1-1000
OR AMS 5213 (200)
OR AMS 5213 (174)
OR ASTM A240
OR ASME SA240

FINISH

FINISH	DART NUMBER
UNPOLISHED No. 1	1P
UNPOLISHED No. 2	2P
UNPOLISHED No. 20	NONE
POLISHED No. 3	3P
POLISHED No. 4	4P
BUFFED No. 5	5P
BUFFED No. 7	7P
BUFFED No. 8	8P

PART NUMBER

A704S TT GA JP
GA

WHERE TT = GAUGE THICKNESS
WHERE JP = FINISH IDENTIFIER

EG 16 GAUGE SS SHEET TO FINISH = M304S186A
EG 16 GAUGE SS SHEET No. 1 POLISHED = M304S186A4P

Gauge Thickness Reference

Gauge	nom. thick (in)	thickness range (in)
20	0.01675	0.0175 - 0.018
18	0.020875	0.021875 - 0.0225
16	0.025	0.02625 - 0.0275
14	0.03125	0.0325 - 0.034
12	0.0375	0.039375 - 0.04125
10	0.04375	0.04625 - 0.04875
8	0.05	0.053125 - 0.05625
6	0.05625	0.060625 - 0.065
4	0.0625	0.0675 - 0.07375
3	0.071875	0.0775 - 0.085
2	0.0875	0.094375 - 0.103125
1	0.125	0.135 - 0.15
3/8	0.140625	0.153125 - 0.1675
1/2	0.15625	0.171875 - 0.18875
5/8	0.1875	0.20625 - 0.2275
3/4	0.21875	0.240625 - 0.2675
1	0.25	0.275 - 0.3125
1 1/4	0.3125	0.34375 - 0.3875
1 1/2	0.375	0.4125 - 0.4625
2	0.4375	0.4875 - 0.54375
2 1/2	0.5	0.5625 - 0.625
3	0.5625	0.625 - 0.7
3 1/2	0.625	0.69375 - 0.775
4	0.6875	0.7625 - 0.85
4 1/2	0.75	0.83125 - 0.9375
5	0.8125	0.9125 - 1.03125
5 1/2	0.875	0.9875 - 1.125
6	0.9375	1.0625 - 1.225
6 1/2	1.0	1.15 - 1.3375
7	1.0625	1.25 - 1.4625
8	1.125	1.34375 - 1.5625
9	1.1875	1.4375 - 1.6875
10	1.25	1.53125 - 1.8125
11	1.3125	1.625 - 1.9375
12	1.375	1.71875 - 2.0625
14	1.5	1.9375 - 2.375
16	1.625	2.125 - 2.6875
18	1.75	2.34375 - 3.0
20	1.875	2.5625 - 3.375
22	2.0	2.75 - 3.75
24	2.125	3.0 - 4.125
26	2.25	3.25 - 4.5
28	2.375	3.5 - 4.875
30	2.5	3.75 - 5.25
32	2.625	4.0 - 5.625
34	2.75	4.25 - 6.0
36	2.875	4.5 - 6.375
38	3.0	4.75 - 6.75
40	3.125	5.0 - 7.125
42	3.25	5.25 - 7.5
44	3.375	5.5 - 7.875
46	3.5	5.75 - 8.25
48	3.625	6.0 - 8.625
50	3.75	6.25 - 9.0
52	3.875	6.5 - 9.375
54	4.0	6.75 - 9.75
56	4.125	7.0 - 10.125
58	4.25	7.25 - 10.5
60	4.375	7.5 - 10.875
62	4.5	7.75 - 11.25
64	4.625	8.0 - 11.625
66	4.75	8.25 - 12.0
68	4.875	8.5 - 12.375
70	5.0	8.75 - 12.75
72	5.125	9.0 - 13.125
74	5.25	9.25 - 13.5
76	5.375	9.5 - 13.875
78	5.5	9.75 - 14.25
80	5.625	10.0 - 14.625
82	5.75	10.25 - 15.0
84	5.875	10.5 - 15.375
86	6.0	10.75 - 15.75
88	6.125	11.0 - 16.125
90	6.25	11.25 - 16.5
92	6.375	11.5 - 16.875
94	6.5	11.75 - 17.25
96	6.625	12.0 - 17.625
98	6.75	12.25 - 18.0
100	6.875	12.5 - 18.375
102	7.0	12.75 - 18.75
104	7.125	13.0 - 19.125
106	7.25	13.25 - 19.5
108	7.375	13.5 - 19.875
110	7.5	13.75 - 20.25
112	7.625	14.0 - 20.625
114	7.75	14.25 - 21.0
116	7.875	14.5 - 21.375
118	8.0	14.75 - 21.75
120	8.125	15.0 - 22.125
122	8.25	15.25 - 22.5
124	8.375	15.5 - 22.875
126	8.5	15.75 - 23.25
128	8.625	16.0 - 23.625
130	8.75	16.25 - 24.0
132	8.875	16.5 - 24.375
134	9.0	16.75 - 24.75
136	9.125	17.0 - 25.125
138	9.25	17.25 - 25.5
140	9.375	17.5 - 25.875
142	9.5	17.75 - 26.25
144	9.625	18.0 - 26.625
146	9.75	18.25 - 27.0
148	9.875	18.5 - 27.375
150	10.0	18.75 - 27.75
152	10.125	19.0 - 28.125
154	10.25	19.25 - 28.5
156	10.375	19.5 - 28.875
158	10.5	19.75 - 29.25
160	10.625	20.0 - 29.625
162	10.75	20.25 - 30.0
164	10.875	20.5 - 30.375
166	11.0	20.75 - 30.75
168	11.125	21.0 - 31.125
170	11.25	21.25 - 31.5
172	11.375	21.5 - 31.875
174	11.5	21.75 - 32.25
176	11.625	22.0 - 32.625
178	11.75	22.25 - 33.0
180	11.875	22.5 - 33.375
182	12.0	22.75 - 33.75
184	12.125	23.0 - 34.125
186	12.25	23.25 - 34.5
188	12.375	23.5 - 34.875
190	12.5	23.75 - 35.25
192	12.625	24.0 - 35.625
194	12.75	24.25 - 36.0
196	12.875	24.5 - 36.375
198	13.0	24.75 - 36.75
200	13.125	25.0 - 37.125
202	13.25	25.25 - 37.5
204	13.375	25.5 - 37.875
206	13.5	25.75 - 38.25
208	13.625	26.0 - 38.625
210	13.75	26.25 - 39.0
212	13.875	26.5 - 39.375
214	14.0	26.75 - 39.75
216	14.125	27.0 - 40.125
218	14.25	27.25 - 40.5
220	14.375	27.5 - 40.875
222	14.5	27.75 - 41.25
224	14.625	28.0 - 41.625
226	14.75	28.25 - 42.0
228	14.875	28.5 - 42.375
230	15.0	28.75 - 42.75
232	15.125	29.0 - 43.125
234	15.25	29.25 - 43.5
236	15.375	29.5 - 43.875
238	15.5	29.75 - 44.25
240	15.625	30.0 - 44.625
242	15.75	30.25 - 45.0
244	15.875	30.5 - 45.375
246	16.0	30.75 - 45.75
248	16.125	31.0 - 46.125
250	16.25	31.25 - 46.5
252	16.375	31.5 - 46.875
254	16.5	31.75 - 47.25
256	16.625	32.0 - 47.625
258	16.75	32.25 - 48.0
260	16.875	32.5 - 48.375
262	17.0	32.75 - 48.75
264	17.125	33.0 - 49.125
266	17.25	33.25 - 49.5
268	17.375	33.5 - 49.875
270	17.5	33.75 - 50.25
272	17.625	34.0 - 50.625
274	17.75	34.25 - 51.0
276	17.875	34.5 - 51.375
278	18.0	34.75 - 51.75
280	18.125	35.0 - 52.125
282	18.25	35.25 - 52.5
284	18.375	35.5 - 52.875
286	18.5	35.75 - 53.25
288	18.625	36.0 - 53.625
290	18.75	36.25 - 54.0
292	18.875	36.5 - 54.375
294	19.0	36.75 - 54.75
296	19.125	37.0 - 55.125
298	19.25	37.25 - 55.5
300	19.375	37.5 - 55.875
302	19.5	37.75 - 56.25
304	19.625	38.0 - 56.625
306	19.75	38.25 - 57.0
308	19.875	38.5 - 57.375
310	20.0	38.75 - 57.75
312	20.125	39.0 - 58.125
314	20.25	39.25 - 58.5
316	20.375	39.5 - 58.875
318	20.5	39.75 - 59.25
320	20.625	40.0 - 59.625
322	20.75	40.25 - 60.0
324	20.875	40.5 - 60.375
326	21.0	40.75 - 60.75
328	21.125	41.0 - 61.125
330	21.25	41.25 - 61.5
332	21.375	41.5 - 61.875
334	21.5	41.75 - 62.25
336	21.625	42.0 - 62.625
338	21.75	42.25 - 63.0
340	21.875	42.5 - 63.375
342	22.0	42.75 - 63.75
344	22.125	43.0 - 64.125
346	22.25	43.25 - 64.5
348	22.375	43.5 - 64.875
350	22.5	43.75 - 65.25
352	22.625	44.0 - 65.625
354	22.75	44.25 - 66.0
356	22.875	44.5 - 66.375
358	23.0	44.75 - 66.75
360	23.125	45.0 - 67.125
362	23.25	45.25 - 67.5
364	23.375	45.5 - 67.875
366	23.5	45.75 - 68.25
368	23.625	46.0 - 68.625
370	23.75	46.25 - 69.0
372	23.875	46.5 - 69.375
374	24.0	46.75 - 69.75
376	24.125	47.0 - 70.125
378	24.25	47.25 - 70.5
380	24.375	47.5 - 70.875
382	24.5	47.75 - 71.25
384	24.625	48.0 - 71.625
386	24.75	48.25 - 72.0
388	24.875	48.5 - 72.375
390	25.0	48.75 - 72.75
392	25.125	49.0 - 73.125
394	25.25	49.25 - 73.5
396	25.375	49.5 - 73.875
398	25.5	49.75 - 74.25
400	25.625	50.0 - 74.625
402	25.75	50.25 - 75.0
404	25.875	50.5 - 75.375
406	26.0	50.75 - 75.75
408	26.125	51.0 - 76.125
410	26.25	51.25 - 76.5
412	26.375	51.5 - 76.875
414	26.5	51.75 - 77.25
416	26.625	52.0 - 77.625
418	26.75	52.25 - 78.0
420	26.875	52.5 - 78.375
422	27.0	52.75 - 78.75
424	27.125	53.0 - 79.125
426	27.25	53.25 - 79.5
428	27.375	53.5 - 79.875
430	27.5	53.75 - 80.25
432	27.625	54.0 - 80.625
434	27.75	54.25 - 81.0
436	27.875	54.5 - 81.375
438	28.0	54.75 - 81.75
440	28.125	55.0 - 82.125
442	28.25	55.25 - 82.5
444	28.375	55.5 - 82.875
446	28.5	55.75 - 83.25
448	28.625	56.0 - 83.625
450	28.75	56.25 - 84.0
452	28.875	56.5 - 84.375
454	29.0	56.75 - 84.75
456	29.125	57.0 - 85.125
458	29.25	57.25 - 85.5
460	29.375	57.5 - 85.875
462	29.5	57.75 - 86.25
464	29.625	58.0 - 86.625
466	29.75	58.25 - 87.0
468	29.875	58.5 - 87.375
470	30.0	58.75 - 87.75
472	30.125	59.0 - 88.125
474	30.25	59.25 - 88.5
476	30.375	59.5 - 88.875
478	30.5	59.75 - 89.25
480	30.625	60.0 - 89.625
482	30.75	60.25 - 90.0
484	30.875	60.5 - 90.375
486	31.0	60.75 - 90.75
488	31.125	61.0 - 91.125
490	31.25	61.25 - 91.5
492	31.375	61.5 - 91.875
494	31.5	61.75 - 92.25
496	31.625	62.0 - 92.625
498	31.75	62.25 - 93.0
500	31.875	62.5 - 93.375
502	32.0	62.75 - 93.75
504	32.125	63.0 - 94.125
506	32.25	63.25 - 94.5
508	32.375	63.5 - 94.875
510	32.5	63.75 - 95

FESS-18G483042B

TRA 3686 52742

MILL TEST CERTIFICATE

Invoice No.: 9QCAEW2602TB6

Steel Grade: AISI 304L

Date: 2018/07/25

Surface Finish: 2B

Page: P02/P04

Goods: STAINLESS STEEL COLD ROLLED SHEETS

Specification: ASTM A240/A480

Certificate No.: PTT702860-TB6

Product ID	Chemical Composition (%)											Mechanical Properties				
	C	Si	Mn	P	S	Ni	Cr	N				Tensile Test			Hardness Test	
												Y.S. (ksi)	T.S. (ksi)	EL (%)	HRB	HV
75S43073B-23	0.018	0.360	0.760	0.037	0.004	0.01	18.09	0.038				287	647	50.0	82	162
75S43073B-24	0.018	0.360	0.760	0.037	0.004	0.01	18.09	0.038				297	647	50.0	82	162
75S43476-7	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-8	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-9	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-A	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-B	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-1	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
75S43476-2	0.029	0.330	0.930	0.035	0.009	0.07	18.05	0.040				268	625	56.0	82	162
76S87832A-1	0.024	0.380	1.370	0.029	0.062	0.03	18.30	0.056				341	683	32.0	90	191
Product ID	Heat No.		SIZE				PCS		Remarks							
75S43073B-23	YU280024		16GA X 60" X 120"				21		REFERRING TO ASTM SPEC P0NUMBER: 12-P-265 LCNUMBER: DC HM0812260 OSLNUMBER: KHRDCTR7829 CERTIFICATE NUMBER: MEDU774102, MEDU6306203 Manager Of QA Dept. K.C.W.							
75S43073B-24	YU280024		16GA X 60" X 120"				20									
75S43476-7	YU187124		18GA X 48" X 96"				49									
75S43476-8	YU187124		18GA X 48" X 96"				49									
75S43476-9	YU187124		18GA X 48" X 96"				49									
75S43476-A	YU187124		18GA X 48" X 96"				49									
75S43476-B	YU187124		18GA X 48" X 96"				54									
75S43476-1	YU187124		18GA X 48" X 120"				33									
75S43476-2	YU187124		18GA X 48" X 120"				33									
76S87832A-1	LZ256A09		18GA X 60" X 120"				50									

We hereby certify that material described herein has been examined and found to conform to the above specifications.

We hereby certify that material described herein has been examined and tested with satisfactory results in accordance with the requirement of the above material specification.

Heat: YU 187124

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					